

Date: Monday, 02/03/2009 11:28:24 AM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE KIT
<b>Job Number</b> : 46214	
<b>Estimate Number</b> : 10532	
<b>P.O. Number</b> :	<b>Part Number</b> : K10003
<b>This Issue</b> : 02/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : 634, 635 IIN
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 45889	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 16/03/2009 <b>Qty:</b> 3 Um: Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.03.02</u>	
<b>Comment</b> : Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est : L 07.01.12 Document Record for copying bluefile rmv KJ Est Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by: Est N 09.01.27 DSI 9418 rev B EC verified by: DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



*Handwritten:* JUD 09/10/02 S 09/10/02

**Comment:** DOCUMENT CONTROL

Create White labels only per PPP K10003

CHG 006

*Handwritten:* per DSI 9417 Rev B

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2570	Bushing
-----	-------	---------

*Handwritten:* S (+3)

**Comment:** Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	1593844

*Handwritten:* 30

4.0	D2571	Saddle, Fwd Out 205
-----	-------	---------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	15921

*Handwritten:* 9/4/6

*Handwritten:* 3X

*Handwritten:* SD

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 11:28:24 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46214

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	45922

6.0

D2573

Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	44206

7.0

D2574

Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	45924

8.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

9.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	43855

2/4/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 11:28:24 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46214

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2876

Spacer

1328662

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2877

Spacer

1339125

13.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Set Screw

Batch:

1344644

14.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

16

AN4-6A

Bolt

11109545

15.0

AN446A

Bolt



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN4-46A

Bolt

1110847

9/4/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 11:28:24 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46214

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M129285

17.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN6-12A

Bolt

M128471

18.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 192.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

32

AN960JD416

Washer

M110363

19.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

8

AN960JD616

Washer

M110404

20.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 174.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

29

MS21042L4

Nut (or MS21042-4)

M109222

9/4/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 02/03/2009 11:28:24 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 46214

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Tow Ring

batch: B44402

22.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch: B43002

23.0

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch: M 111177

24.0

D34175

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: B43275

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Rev 9/4/06

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D2968-041	TOW RING
41	1	1				AN970-4	WASHER
43	1	1				MS21042L4	NUT (OR MS21042-4)
50					1	D2736-1	GHW LUG
51					1	D2736-3	GHW LUG
52					4	AN4-46A	BOLT
53					8	D2570	BUSHING
54					4	MS21042L4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E  
 Date: 08.04.15  
 WORK ORDER NO. 4024

SHOP COPY  
 RETURN TO  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

## 5.0 D204-635-011 SKIDTUBE INSTALLATION PARTS LIST

Item	635 -011	635 -041	641 -011	Part Number	Description
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT
1		1		D2590-041	204 SKIDTUBE ASSEMBLY
2A		10		D2594-1	* PLUG
2B		10		D2594-3	* O-RING
3		1		D2855	* AFT CAP
4		2		AN3-5A	* BOLT
5		2		AN960JD10L	* WASHER
6A		1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B		1		D3566-1	* GASKET
7A		1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B		1		D3566-1	* GASKET
8A		1		D3564-7	* WEARSHOE (REPLACES D2577-7)
8B		1		D3566-7	* GASKET
9A		1		D3564-13	* WEARSHOE
9B		1		D3566-13	* GASKET
10		44		AN3C4A	* BOLT (REPLACES AN3-4A)
11		44		AN960C10L	* WASHER (REPLACES AN960JD10L)
12		44		ALS4-1032-130	* INSERT
13		2		ALS4-1032-225	* INSERT
20	1			D2571	SADDLE, FWD OUTSIDE
21	1			D2572	SADDLE, FWD INSIDE
22	1			D2573	SADDLE, AFT OUTSIDE
23	1			D2574	SADDLE, AFT INSIDE
24	8			AN4-51A	BOLT
25	16			D2570	BUSHINGS
26	8			MS21042L4	NUT (OR MS21042-4)
27	8			AN6-12A	BOLT
28	8			AN960JD616	WASHER
29	16			AN4-6A	BOLT
30	32			AN960JD416	WASHER
31	16			MS21042L4	NUT (OR MS21042-4)
32	4			D2747	SET SCREW
33	2			D3533-1	SET SCREW
40	1			D2968-041	TOW RING
41	1			AN970-4	WASHER
43	1			MS21042L4	NUT (OR MS21042-4)
50			1	D2736-1	GHW LUG
51			1	D2736-3	GHW LUG
52			4	AN4-46A	BOLT
53			8	D2570	BUSHING
54			4	MS21042L4	NUT (OR MS21042-4)
60	2			D2876	SADDLE SPACER
61	2			D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

WORK ORDER

Date: 08.04.15